

20-7965



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3136-043
Job Sheet 203137



Part No: D3136-043

Job Qty: 4 pcs

DAS
27
9-06

Part Name: Window Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/11/19

Job Tracking No:

Due Date: 11/27/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV F IPP Rev:A 04.02.04 New issue KJ/DS IPP Rev.B 07.05.29 Thermoform in-house DL IPP rev C
07.09.28 Rev E dwg EC verified by:DD IPP Rev:D 10.06.24 added note in qc5 seq 170 DD ver:EC IPP Rev E
14/01/20 Replace "Folio" with Work Instruction DL

Ship Via:

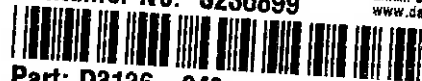
Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Sign-off
110	Purchasing	4 pcs	11/27/19	11/27/19	0.00	0.00	Purchasing - 1	DEC 03 2019
							Purchasing - 2	
							Purchasing - 3	
140	Packaging 2-1 - Receive - B4B	4 pcs	11/27/19	11/27/19	0.00	0.00	Packaging 2 - 1 - B4B	
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	DEC 03 2019
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
							Packaging 2 - 16 - B4B	
							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	



Container No: S236899



Part: D3136-043

Job No: 203137

Serial No/Batch: S236899

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/03/19

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

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P.T.O.

					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
150 QC 6	4 pcs	11/27/19	0.00 0.00		QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
					QC 6 - 81	
155 Small Fab - 2 - B4B	4 pcs	11/27/19	0.00 0.03		Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
					Small Fab - 9 - B4B	
165 QC 5	4 pcs	11/27/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
170 Packaging 3-1 - Stock - B4B	4 pcs	11/27/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	

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DEC 03 2019

DEC 03 2019

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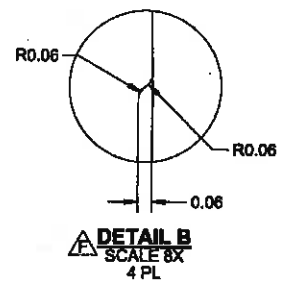
DEC 03 2019

				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	DAS 78
				Packaging 3 - 25 - B4B	9-89 DEC 03 2019
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	4 pcs	11/27/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	DAS 21 DEC 03 2019
Part Op 110 - Purchasing Descriptions: 140 - Receive & Inspect for Damage & Mat'l Certs 150 - QC6- All purchased or subcontracted products 155 - INSTALL LABELS AND ENGRAVE AS PER NOTE 6 165 - QC5- Inspect part completeness to step on W/O 170 - Identify as per dwg & Stock Location: 180 - QC21- Final Inspection - Work Order Release 804B045067 x4 Hls 11 SEPT 2019					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D3136-043P	Window Assembly	4 pcs (1 ea)	110-Purchasing	S236896	
MACRLICS.125	1/8" Polycast li Sheet	21.3200 sf (5.33 ea)	110-Purchasing	S151992	
D3108-9	Decal	8 pcs (2 ea)	155-Small Fab - 2 - B4B	S157557	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-Purchasing	D3136-043P	4	0	0	
	MACRLICS.125	21	1,535	0	
155-Small Fab - 2 - B4B	D3108-9	8	176	0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Window Assembly	21.000Inches ± 0.030	21.030 20.970		
2	Window Assembly	25.750Inches ± 0.030	25.780 25.720		
3	Window Assembly	26.250Inches ± 0.030	26.280 26.220		

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SHIP COPY
RETURN TO
ENGINEER

UNCONTROLLED
SUBJECT TO
WITHOUT
WORK
NO. 203177MLS
19-11-11



RELEASED
2015-07-12

D3136-3 WINDOW
D3136-043 WINDOW ASSEMBLY
(INCLUDES D3108-9 DECALS)

NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLASS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK, (REF DART SPEC M-ACRYLIC-S.125)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3136-043" AND B/N PER DART QSI 044 6.4 (0.125" HIGH LETTERS/MAX DEPTH 0.005")
- 7) WEIGHT: 2.9 +/- 0.25 lbs
- 8) FORMING PROCESS: a) HEAT SHEET TO 250° F
b) DRAPE OVER D3136-T1 MOLD AND CLAMP
c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	DB	DRAWING NO.	REV. F
MFG. APPR.	AS	D3136	SHEET 2 OF 3
APPROVED	MT	TITLE	SCALE
DE APPR.		SPACEDOOR WINDOW	NTS
DATE	14.12.10	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED TO THE BUYER UNDER CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT THE PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB045067



Supplier: PTF001-VC
Plas-Tech Fabrications
128 Walgreen Road
Ottawa
ON
K0A 1L0 Canada
Phone: 613-831-4640
Fax: 613-831-4624

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045067
PO Date: 11/11/19
Due Date: 12/3/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items															
Line Item	Job	Part	Drawing	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price	
1	203137	D3136-043P	D3136 Rev.F			Window Assembly : Various STC's receive pcs	Firmed X4	-	12/3/19	4 pcs	0 pcs	4 pcs	\$248.75/pcs	\$995.00	AS 40 9-89
Grand Total:														\$995.00	

Order Notes

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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128 WALGREEN ROAD
CARP. ON K0A 1L0
PHONE-613-831-4640
FAX-613-831-4624

CERTIFICATE OF COMPLIANCE

SOLD TO: DART AEROSPACE

DATE: December 3, 2019

YOUR PURCHASE ORDER: PO HB045067

OUR INVOICE NO: 37812

LINE ITEM # 1

QUANTITY: 4

DESCRIPTION: SPACE DOOR WINDOW PER DWG D3136-043P REV F.

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THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH:

DART QSI 018

PLASTECH PROCESS PR-01-01-D3136-043P REV 1.0 USING DWG D3136-043P REV F.

Note: USED 2 SHEETS - 56 SF OF PLEXIGLASS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF DART SPEC. M-ACRYLIC-S.125). BATCH# S151992.

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS OF THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE PROCUREMENT SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND LATEST REVISIONS AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

AUTHORIZED REPRESENTATIVE SIGNATURE

A handwritten signature in black ink, appearing to read 'Mark Perry', is written over a horizontal line.

MARK PERRY, M.ENG.
PRESIDENT

Form 1: Part Number Accountability

1. Part Number D3136-043P	2. Part Name SPACEDOOR WINDOW	3. Serial Number 2019-001	4. FAI Report Number FAIR-D3136-043P REV F
5. Part Revision Level Rev. F	6. Drawing Number D3136 (SHEET 2 OF 3)	7. Drawing revision level Rev. F	8. Additional Changes NA
9. Manufacturing Process Reference PR-01-01-D3136-043P REV1.0	10. Organization Name Plas-Tech Fabrications Inc.	11. Supplier Code PTF001	12. P.O. Number POHB045067 (ITEM# 1)
13. Detail FAI ☒ Assembly FAI ☐	14. Full FAI ☒ Partial FAI ☐ Reason for Partial FAI:	Baseline Part Number including revision level	
a) if above part number is a detail part only, go to Field 19 b) if above part number is an assembly, go to the "INDEX" section below.			
INDEX of part numbers or sub-assembly numbers required to make the assembly noted above.			
15. Part Number	16. Part Name	17. Part Serial Number	18. FAI Report Number
1) Signature indicates that all characteristics are accounted for; meet drawing requirements or are properly documented for disposition.			
2) Also indicate if the FAI is complete per Section 5.4: ☒ FAI complete		☐ FAI not Complete	
19. Signature 		20. Date 12-02-2019	
21. Reviewed By		22. Date	
23. Customer Approval		24. Date	

Form 2: Product Accountability – Raw Material, Specifications and Special Process(es), Functional Testing

1. Part Number D3136-043P	2 Part Name SPACEDOOR WINDOW		2. Serial Number 2019-001		4. FAI Report Number FAIR-D3136-043P REV F
5. Material or Process Name	6. Specification Number	7. Code	8. Special Process Supplier Code	9. Customer Approval Verification (Yes/No/NA)	10. Certificate of Conformance number
PLEXIGLAS G CLEAR CAST ACRYLIC SHEET	LP-391 TYPE 1 GRADE C, 0.125 THICK REF. DART SPEC. M-ACRYLIC-S.125		N/A	N/A	N/A Supplied by Customer, DART
11. Functional Test Procedure Number	12. Acceptance report number, if applicable				
13. Comments					
14. Prepared By Mark Perry Plas-Tech Fabrications			15. Date 12-02-2019		

SAE AS9102 First Article Inspection Form

Form 3: Characteristic Accountability, Verification and Compatibility Evaluation

Sheet 1 of 3

1. Part Number D3136-043P				2. Part Name SPACEDOOR WINDOW		3. Serial Number 2019-001	4. FAI Report FAIR-D3136-043P REV F
Characteristic Accountability				Inspection / Test Results			14. Remarks.
5. Char No.	6. Reference Location	7. Characteristic Designator	8. Requirement	9. Results	10. Designed Tooling	11. Non-Conformance Number	
1	8A-SH2, Eng. Note 1		MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125	CHECKED Plexiglas G Acrylic sheet .125			Material supplied by customer _ Dart Material M-ACRYLICS.125 Batch# S151992.
2	7B-SH2		D3108-9 DECAL. INSTALL ON INSIDE CORNERS OF WINDOW 2 PL	NOTED			THIS ITEM TO BE COMPLETED AT DART AEROSPACE LOCATION.
3	8A-SH2, Eng. Note 3		TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED	NOTED			
4	8A-SH2, Eng. Note 4		UNITS: INCHES UNLESS OTHERWISE NOTED	NOTED			
5	8A-SH2, Eng. Note 5		BREAK SHARP EDGES: 0.005 TO 0.010 MAX	SCRAPED BOTH EDGES TO 0.010 MAX.			
6	8A-SH2, Eng. Note 6		IDENTIFICATION: IDENTIFY WITH DART P/N "D3136-043" AND B/N PER DART QSI 044 6.4 (0.125" HIGH LETTERS / MAX DEPTH 0.005")	NOTED			- Tag or label only by Plas-Tech - Final Identification to be completed by Dart per Eng. Note 6.
7	8A-SH1, Eng. Note 7		WEIGHT: 2.9 +/- 0.25 Lbs.	3 LB			PLASTECH WEIGH SCALE IS +/- 1 LB ACCURACY.

Form 3: Characteristic Accountability, Verification and Compatibility Evaluation

Sheet 2 of 3

1. Part Number D3136-043P				2. Part Name SPACEDOOR WINDOW			3. Serial Number 2019-001	4. FAI Report FAIR-D3136-043P REV F
Characteristic Accountability				Inspection / Test Results				
5. Char No.	6. Reference Location	7. Characteristic Designator	8. Requirement	9. Results	10. Designed Tooling	11. Non-Conformance Number	14. Remarks.	
8	8A-SH2, Eng. Note 8		FORMING PROCESS: a) HEAT SHEET TO 250F. b) DRAPE OVER D3136-T1 MOULD AND CLAMP c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS.	NOTED	MOULD D3136-T1			
9	8D-SH2		0.52 REF	0.71				
10	7D-SH2		7.4 REF	0.70				
11	3D-SH2		3M MASKING FILM THIS SIDE ONLY	NOTED				
12	5D-SH2		25.75	25.50				
13	3D-SH2		R3.60 TYP	3.6				
14	8C-SH2		R140 REF	COMPLIANT			THIS FEATURE IS CONTROLLED BY MOULD	
15	7C-SH2		21.00	20.8				
16	7C-SH2		2.25 TYP	NOT USED			DECAL ADDED LATER SO THIS ITEM NOT USED.	

Form 3: Characteristic Accountability, Verification and Compatibility Evaluation

Sheet 3 of 3

1. Part Number D3136-043P				2. Part Name SPACEDOOR WINDOW			3. Serial Number 2019-001	4. FAI Report FAIR-D3136-043P REV F
Characteristic Accountability				Inspection / Test Results				
5. Char No.	6. Reference Location	7. Characteristic Designator	8. Requirement	9. Results	10. Designed Tooling	11. Non-Conformance Number	14. Remarks.	
17	5B-SH2		26.25	25.9				
18	3B-SH2		4.00 2 PL	4.0				
19	3B-SH2		4.00 2 PL	4.0				
20	2C-SH2		0.06	0.06				
21	1C-SH2		R0.06	0.06				
22	2C-SH2		R0.06	0.06				
The signature indicates that all characteristics are accounted for; meet drawing requirements or are properly documented for disposition.								
12. Prepared By Mark Perry, Plas-Tech Fabrications 						13. Date 12-02-2019		

Plas-Tech Fabrications Inc.

128 Walgreen Rd
Stittsville, Ont
K0A 1L0

Ph: 613-831-4640
Fx: 613-831-4624

Packing Slip

Packing Slip No.:

Date:

Page:

37812

Dec 02, 2019

Sold to:	Ship to:
DART AEROSPACE 1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7	DART AEROSPACE 1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7 POHB045067
Order No.: 23033	Sold By: Mark Perry
Shipped By:	Ship Date: Dec 02, 2019
Tracking No.:	

Item No.	Unit	Description	Quantity
Misc	Each	Drawing# D3136-043P Rev F. Space Door Window. RECEIVED DEC 03 2019 DART AEROSPACE LTD.	4
Comment: Thank you for your order.			

JR Date: Feb 14/2020



20-7965

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev J